




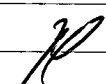




Work Order ID 63224

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
Item ID:	D3580-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Joggle Bracket				Stop	
Start Date:	10/25/2010	Start Qty:	100.00		Cust Item ID:	
Required Date:	10/29/2010	Req'd Qty:	100.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-10-25	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3580	Rev B								


100		0.00							
-----	--	------	--	--	--	--	--	--	--

	FLOW WATER JET								
Waterjet									
	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3580								
304 .050	Dwg Rev: 								
	Prog Rev: 								
	2-Deburr if necessary								

10-10-26


134

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

									
QC									
Quality Control	Memo	0.00							

10-10-26

120	QC8- Inspect parts - second check	0.00							
-----	-----------------------------------	------	--	--	--	--	--	--	--

									
QC									
Quality Control	Memo	0.00							

8/10/10/27

counted
x134

QSP019

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Item ID: D3580-1

Accept



Setup Start



Revision ID:

Item Name: Joggle Bracket

Stop



Start Date: 10/25/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Bend as per dwg D3580 using 1/8" offset die

SB 10/10/28

ES 10/10/28 (134)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S 10/10/28

counted
(134)
QSP011

150

0.00



Identify as per dwg & Stock Location: 68

Packaging

Memo

0.00

Packaging

10/10/28 (134) SP

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Item ID: D3580-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Joggle Bracket

Start Date: 10/25/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29 JF

H/10-10-28
134

Picklist Print

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Work Order ID: 63224



Parent Item: D3580-1



Parent Item Name: Joggle Bracket



Start Date: 10/25/2010

Required Date: 10/29/2010

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev :A New Issue 07.06.25 EC
IPP Rev:B Removed Powder Coat 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA  304/316 .050 Sheet		Purchased	No			100	sf	93.4200	0.01	1.052632	1.4		
											B 10-10-26		

Location

Loc Qty

Loc Code

MAT20

93.42

111743

5.25

113062

40.17

115389

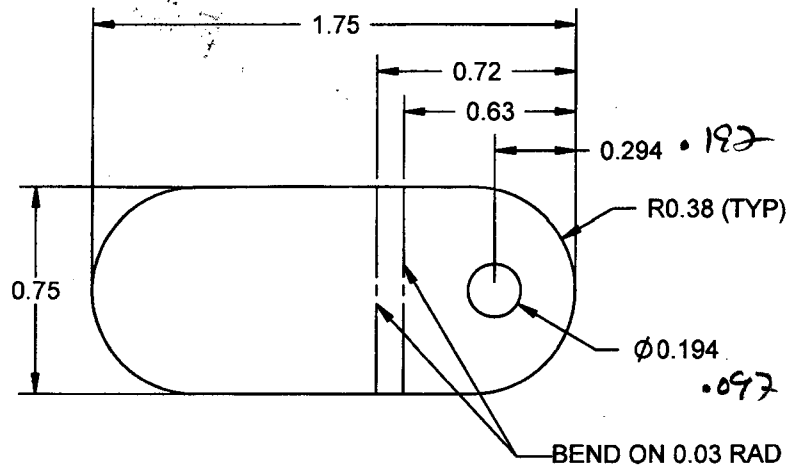
48

113062

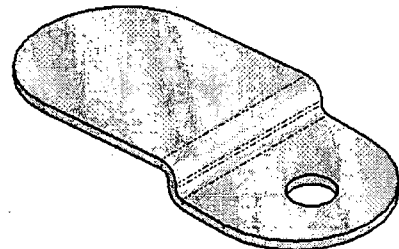
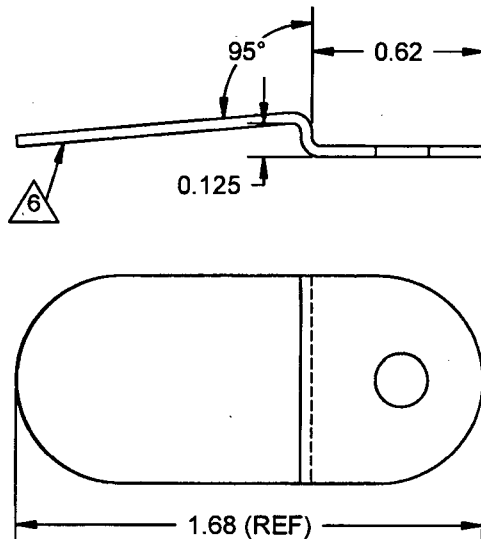
134

DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3580	REV. B SHEET 1 OF 1
DATE 07.07.09		TITLE JOGGLE BRACKET	SCALE 3:2
REV	DATE	DESCRIPTION	
A	07.05.15	NEW ISSUE	
B	07.07.09	REMOVE POWDER COAT	

RELEASED07.07.09 *[Signature]***D3580-1F FLAT PATTERN**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO *63224*

28-10-25**D3580-1 JOGGLE BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER
ON THE UNDERSIDE OF THE PART AS INDICATED

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